

Tuesday, July 12, 2016 8:54:09 AM

1 48900

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Doubler

Start Date: 7/7/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/12/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:**

Date **JUL 13 2016**

Tooling:

Date:

Run Start *NR1*

QC: 9-89

Date:**SPC (Y/N):**

Date:

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148900

Tuesday, July 12, 2016 8:54:09 AM

148900

Page 2

Item ID: D3609-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 7/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/12/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

DAS
38

AUG 16 2016

P.T.O.

121

Form as per dwg

0.00

121

Brake NC

Memo

0.06

Brake NC

USE DT9760 TOOL

DAS
30
9-89

9

SEP 26 2016

122

0.00

122

Small Fab

Memo

0.00

Small Fab

1- TRIM AS PER DWG USING GUIDE LINES
2- BUFF SCRATCHS WITH LINE MATE (RED SCOTCH BRIGHT) TOP
SURFACE ONLYDAS
30
9-89

139

SEP 26 2016

DQA:

Date: Jan 4 2017QA Closed: [Signature]Date: OCT 12 2016

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>148500</u> Part No. <u>D3609-1</u> NCR No. <u>16-6089</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☒</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☒	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16-09-28</u>		Step #: <u>122</u>		QTY Effective: <u>(3)</u>		MRB (QSI042) Approval DAS 9 9-89 <u>1609-28</u>																																																																	
Description Work Order Deviation <u>was not cut to drawing</u> <u>2.c. operator place sheet upside down</u> <u>3 parts were to scratch during bending</u> <u>RC handling</u>				Disposition <u>Scrap + destroy</u> <u>No replace</u>				Completed By DAS 30 9-89 <u>SEP 26 2016</u>																																																															
				Lead hand / Supervisor Approval Verification DAS 38 9-89 <u>SEP 26 2016</u>																																																																			
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Work Order ID 148900

Tuesday, July 12, 2016 8:54:09 AM

148900

Page 3

Item ID: D3609-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 7/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/12/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC5- Inspect part completeness to step on W/O	0.00							
123									
QC	Memo	0.01							DAS 38 9-89
Quality Control									SEP 26 2016
130	Identify as per dwg & Stock Location: <u>5220</u>	0.00							
130									
Packaging	Memo	0.01							9 SEP 27 2016 DAS 6 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.07							DAS 21 9-89
Quality Control									SEP 28 2016

DAS
21
9-89

SEP 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, July 12, 2016 8:54:08 AM

Page 1

Work Order ID: 148900

148900

Parent Item: D3609-1

D3609-1

Parent Item Name: Doubler

Start Date: 7/7/2016

Required Date: 7/12/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C
AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA4P

Purchased

No

sf

32.0000

4.95579

M304S22GA4P

**

2-16/08/14

304/316 Sheet .032

Location

Loc Qty

Loc Code

MAT020

32

m126571

32

15

DQA: _____ Date: _____

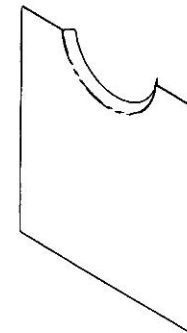
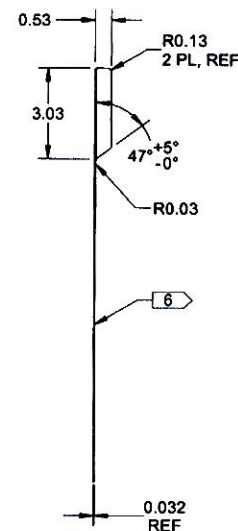
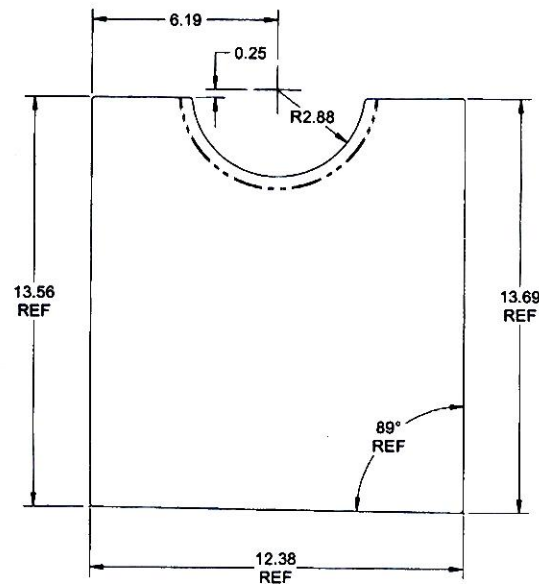


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER : ☐			



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148900 MJS
16-0713

RELEASED
2011-10-04
JW

D3609-1 DOUBLER

NOTES:

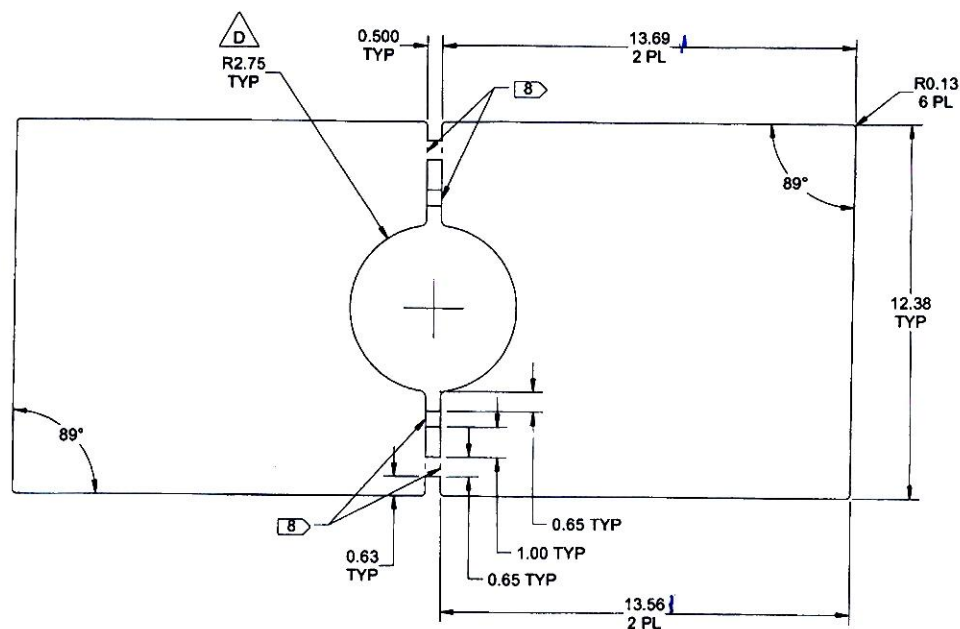
- 1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.46 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2

D	REVISE FLAT PATTERN SYMMETRY; R2.75 WAS R2.83 (ZN C6-2)	RF	11.08.20
C	2.88 WAS 2.98 (ZN C5-1); 3.03 WAS 3.20 (ZN C4-1); 0.53 WAS 0.50 (ZN C4-1); ADD ANGLE TOLERANCE (ZNC3-1); REVISE D3609-1F	RF	11.08.07
B	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.04.28
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3609** REV. D
SHEET 1 OF 2
TITLE **DOUBLER** SCALE NTS

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0.032
REF

RELEASED
2011-10-04

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM 240
OR ASME SA240
PER DART SPEC M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.93 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE

D3609-1F FLAT PATTERN
(MAKES 2 PARTS)



DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3609	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.09.20	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			